

Date: Tuesday, 12/12/2006 10:29:54 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 29885
 Estimate Number : 11026
 P.O. Number : N/A
 This Issue : 12/12/2006 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : N/A
 Drawing Name : CROSS BEAM
 Part Number : D2764
 Drawing Number : D2764 REV D
 Project Number : N/A
 Drawing Revision : D
 Material : N/A
 Due Date : 1/15/2007 Qty: 6 Um: Each
 Written By : [Signature]
 Checked & Approved By : [Signature]
 Comment : Est. D 00.08.14 Added note at step #1 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02500 6061-T6 Bar 1.0" x 2.5"



Comment: Qty.: 4.2875 f(s)/Unit Total: 25.7248 f(s)
 6061-T6 Bar 1.0" x 2.5"
 Material: 1" X 2.5" 6061-T6 (QQ-A-200/8)
 Batch No: M103019

J.F. 06/12/22 (6)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut Blanks: 48.5"
 *** RUN D2796 WITH SAME PROG. ***

J.F. 06/12/22 (6)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per Folio D2764
 Deburr

J.L. 06/12/24

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 06/12/24

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1







Comment: HAND FINISHING RESOURCE #1
 Acid etch and Alodine as per QSI 005 4.1

m.e. / yk 06/12/27 (6x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-04	3.0	A Knick, roughly .020" deep was noticed on the pocket side edge of the material on the LH end of the Beam. Knick was probably caused by the part being hit by a tool. cosmetic, not structural.	 QS1042	Fill knick with weld as necessary as per QS1004, i buff smooth. Touch-up spot with Alacine.	BE 07-01-04	 07/01/04	 QS1042	 07-01-04

NOTE: Date & initial all entries

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Drawing Name: CROSS BEAM

Job Number: 29885

Part Number: D2764

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



11102391



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FX/ m. h/ 07/01/10 (2x) 04/01/09 (6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/01/12

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5154*

JB 07/01/12 (6) 07/01/12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/12 (6) 07/01/12

Job Completion



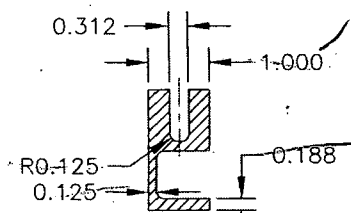
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

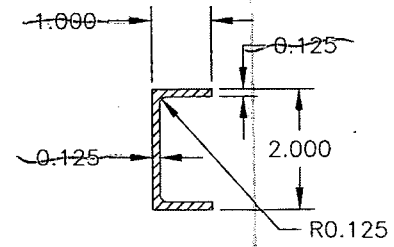
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

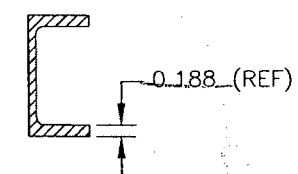
NOTE: Date & initial all entries



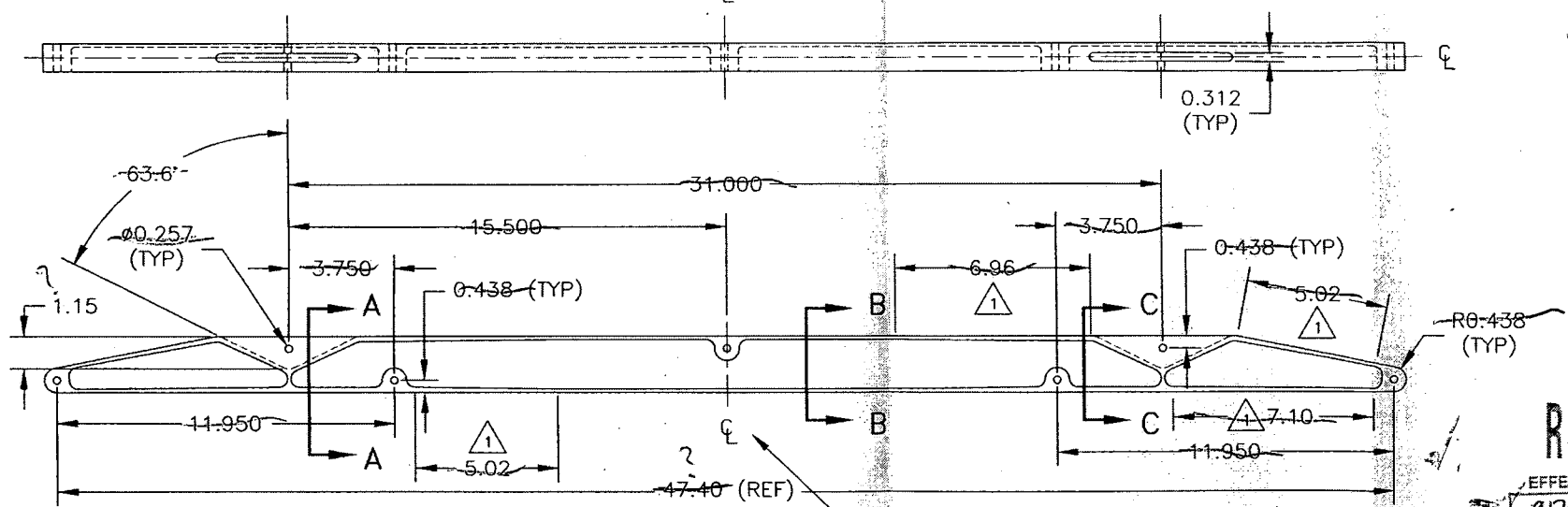
SECTION A-A
SCALE 1:2



SECTION B-B
SCALE 1:2



SECTION C-C
SCALE 1:2



PART IS SYMMETRIC
ABOUT THIS CENTER LINE

RELEASED
98.11.18 KE

EFFECTIVE	DEQs
9/26	

NO. 29885
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) KE
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 98.12.07
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 T5R A 1051
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

1 TAPERED WALL THICKNESS FROM 0.188 TO 0.125 OVER INDICATED LENGTH

D	98.11.09	TAPERED WALLS ADDED
C	98.09.01	MACHINED PART WAS BOX BEAM
B	98.06.17	ADD LARGE HOLES & STIFFENER
A	98.04.14	NEW ISSUE
DESIGN	KE	DRAWN BY KE
CHECKED	KE	APPROVED KE
DATE	98.11.09	TITLE CROSS BEAM
DRAWING NO.	D2764	REV. D
		SHEET 1 OF 1
		SCALE 1:4

DART AEROSPACE LTD		Work Order:
Description:		Part Number:
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
312	±.010	316	✓			
1.000	"	1.003	✓			
.125	"	.129	✓			
.188	"	.187	✓			
.125	"	.125	✓			
2.000	"	2.003	✓			
5.125	"	.125	✓			
Ø.257	+ .006 - .001	.260	✓			
11.950	±.010	11.950	✓			
.438	"	.439	✓			
3.750	"	3.751	✓			
31.000	"	31.000	✓			
15.500	"	15.501	✓			
47.40	±.030	47.40	✓			
1.15	±.030	1.151	✓			

Measured by: J.L	Audited by: En	Prototype Approval:
Date: 06/12/23	Date: 06/12/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	